

## Patent Claims

1. (currently amended) Method for producing blanks from cardboard ~~(1a, b, c)~~ or and board-like materials for product sales purposes, whereby the workpieces originally of any initial shape are blanked by selected ones of longitudinal (2) or and transverse (3) cut lines, ~~as the case may be~~, into the a layout of a box structure (4) to be manufactured, and ~~also have~~ other processing lines (5a, 5b) that run in neither the longitudinal nor the transverse directions, **characterized by the fact that** wherein the other processing lines (5a, 5b) ~~that run in neither the longitudinal nor the transverse directions~~ are produced by a processing device (7) movable parallel to and relative to the plane of the material to be blanked, that can be caused to travel at a prescribed distance (10) from the material to any point on ~~this~~ the processing lines, and activated for processing, and is driven (11, 12) in the activated state along the processing lines (5a, 5b) with controlled (13, 14, 19) feed in the a processing direction.
2. (currently amended) Method pursuant to Claim 1, **characterized by the fact that** wherein the other processing lines (5a, 5b) are produced in a process step prior to the processing steps for producing the longitudinal and transverse cut lines (2, 3) ~~as the case may be~~.
3. (currently amended) Method pursuant to Claim 1 or 2, **characterized by the fact that** wherein the other processing lines (5a, 5b) are produced in a process step that follows in time the production of the longitudinal and transverse cut lines (2, 3).
4. (currently amended) Method pursuant to ~~one of the claims 1 to 3~~, **characterized by the fact that** wherein the other processing lines (5a) are cut lines that are produced by a ~~processing device designed as a cutter~~ (20).

5. (currently amended) Method pursuant to Claim 4, ~~characterized by the fact that wherein~~ the other ~~cut~~ processing lines (5a) are continuous except for predetermined hold points (16), with the hold points fastening the a chip (17) to the rest ~~a remainder~~ of the blank (18).
6. (currently amended) Method pursuant to Claim 5, ~~characterized by the fact that wherein~~ the other ~~cut~~ processing lines (5a) are produced by a the cutter (20) which is controlled digitally by an associated EDP system (19).
7. (currently amended) Method pursuant to one of the claims 1 to 6, ~~characterized by the fact that wherein~~ the other processing lines (5b) comprise adhesive points and that the processing device (7) is an adhesive device (21).
8. (currently amended) Method pursuant to Claim 7, ~~characterized by the fact that wherein~~ the adhesive device (21) is digitally controlled by an associated EDP system (19) and includes an adhesive applicator (22) that can be made to travel to any point on the blank (~~1a, b, c~~) and can be activated in the sense of discharging to discharge adhesive.
9. (currently amended) Method pursuant to Claim 8, ~~characterized by the fact that wherein~~ the adhesive applicator (22) can be activated pointwise.
10. (currently amended) Method pursuant to one of the claims 7 to 9 8, ~~characterized by the fact that wherein~~ the adhesive applicator (22) remains activated during the controlled travel motion.
11. (currently amended) Method pursuant to one of the claims 1 to 6, ~~characterized by the fact that wherein~~ the other processing lines are comprise at least one of creases, perforations, milled, or marking lines, that are produced with a correspondingly designed processing device, with the processing occurring along

a straight-line processing path on the workpiece with preceding and following process steps, in an in-line machine.

12. (currently amended) ~~Device by implementation of the method pursuant to Claim 1,~~ **characterized by the fact that** A device for producing blanks from cardboard-like material, the device comprising a fixed-location processing station (40) is provided, in which the a workpiece (1a, b, c) to be processed is held, and that has a processing device (7) mounted in fixed location relative to the held workpiece, with and a processing head (9) that can be caused to travel to any point on the workpiece, and which can be activated or deactivated depending on its the particular position thereof.
13. (currently amended) Device pursuant to Claim 12, **characterized by the fact that** wherein the processing head (9) rests on two fixed-location guidance systems (24a, 24b, 25a, 25b) that are movable perpendicularly to one another.
14. (currently amended) Device pursuant to Claim 12, **characterized by the fact that** wherein the processing head (9) rests on a boom (26) that can be rotated and extended in the manner of a robot arm is rotatable and extendible.
15. (currently amended) Device pursuant to ~~one of the claims 12 to 14,~~ **characterized by the fact that** claim 14, wherein there are at least two processing heads (9, 9') that are operated operable in unison or and at staggered times.
16. (currently amended) Device pursuant to ~~one of the claims 12 to 15,~~ **characterized by the fact that** claim 12, wherein the processing head (9, 9') has is provided with a cutter (20) pointing toward the workpiece (1a, b, c).
17. (currently amended) Device pursuant to Claim 16, **characterized by the fact that** wherein the cutter (20) comprises a stationary or rotating knife.

18. (currently amended) Device pursuant to Claim 16, ~~characterized by the fact that~~ wherein the cutter (20) operates by the a selected one of laser, water jet, or and sand jet principle.
19. (currently amended) Device pursuant to ~~one of the claims 12 to 16,~~ ~~characterized by the fact that~~ wherein the processing head (9) carries a perforator.
20. (currently amended) Device pursuant to ~~one of the claims 12 to 16,~~ ~~characterized by the fact that~~ wherein the processing head (9) carries a scoring or creasing device.
21. (currently amended) Device pursuant to ~~one of the claims 11 to 20,~~ ~~characterized by the fact that~~ claim 12, wherein the processing head (9) carries a marking device.
22. (currently amended) Device pursuant to ~~one of the claims 12 to 21,~~ ~~characterized by the fact that~~ claim 21, wherein the processing head (9) has is provided with a glue discharge nozzle (27) pointing toward the workpiece ~~(1a, b, c).~~
23. (currently amended) Device pursuant to Claim 22, ~~characterized by the fact that~~ wherein the glue discharge nozzle (27) is connected to a heater (28).
24. (currently amended) Device pursuant to Claim 22 ~~or 23,~~ ~~characterized by the fact that~~ wherein the glue discharge nozzle is provided with a controllable ~~(30)~~ discharge valve (29).

25. (currently amended) Device pursuant to ~~one of the claims 22 to 24,~~  
~~characterized by the fact that~~ 12, wherein the fixed-location processing station  
(40) is followed by a pressing station (31).